

Date: Tuesday, 1/16/2007 11:28:50 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT ASSEMBLY		
Job Number	: 30276					
Estimate Number	: 10464					
P.O. Number	: N/A			Part Number	: D3278041	
This Issue	: 1/16/2007 S.O. No. : N/A			Drawing Number	: D3278 REV. B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: 30150			Material	: N/A	
Written By	: <i>JKJ</i>			Due Date	: 1/26/2007	
Checked & Approved By	: <i>JKJ</i>			Qty:	40	
Comment	: Est:A 04.04.19 New issue KJ/JLM			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	30276A	SUPPORT	
		<i>Comment: Sub-Component SUPPORT D3278-1 B B 30276 A x 40</i>	<i>ml07/02/21</i>
2.0	30276B	SUPPORT	
		<i>Comment: Sub-Component SUPPORT D3278-2 B 30150 B x 6 / B 30276 B x 34</i>	<i>ml07/02/21</i>
3.0	D32783	Spacer	
		<i>Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Spacer Pick: Qty Part Number Description Batch 1 D3278-3 Spacer B 30291 x 40</i>	<i>ml07/03/21</i>
4.0	MS20426AD37	RIVET	
		<i>Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s) RIVET Pick: Qty Part Number Description Batch 4 MS20426AD37 Rivet M16527</i>	<i>can not poker out from inv.</i> <i>ml07/03/21</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		<i>Comment: SMALL & MEDIUM FAB RESOURCE 1 Rivet spacers with support as per Dwg D3278.</i>	<i>ml07/02/21</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SUPPORT ASSEMBLY

Job Number: 30276

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/02/01

40

7.0 D22301 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Mounting Lug

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1 Mounting Lug

X17

B29377

B30155

Not in system

8.0 AN413A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-13A Bolt

M101149 X2

M103177 X78

✓

9.0 AN960JD416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD416 Washer

M103338 X144

M100575 X16

✓

10.0 MS21042L4 Nut



✓

Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L4 Nut

M19085 X6

M103349 X74

ml07/02/23

x40

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

DO NOT TIGHTEN BOLTS

Identify as D3278-041

ml07/02/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/02/23

40

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST105

P 07/2/26 40

14.0 QC21 FINAL INSPECTION/W/O RELEASE



40

Comment: FINAL INSPECTION/W/O RELEASE

107/02/27

Job Completion



u 07/02/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

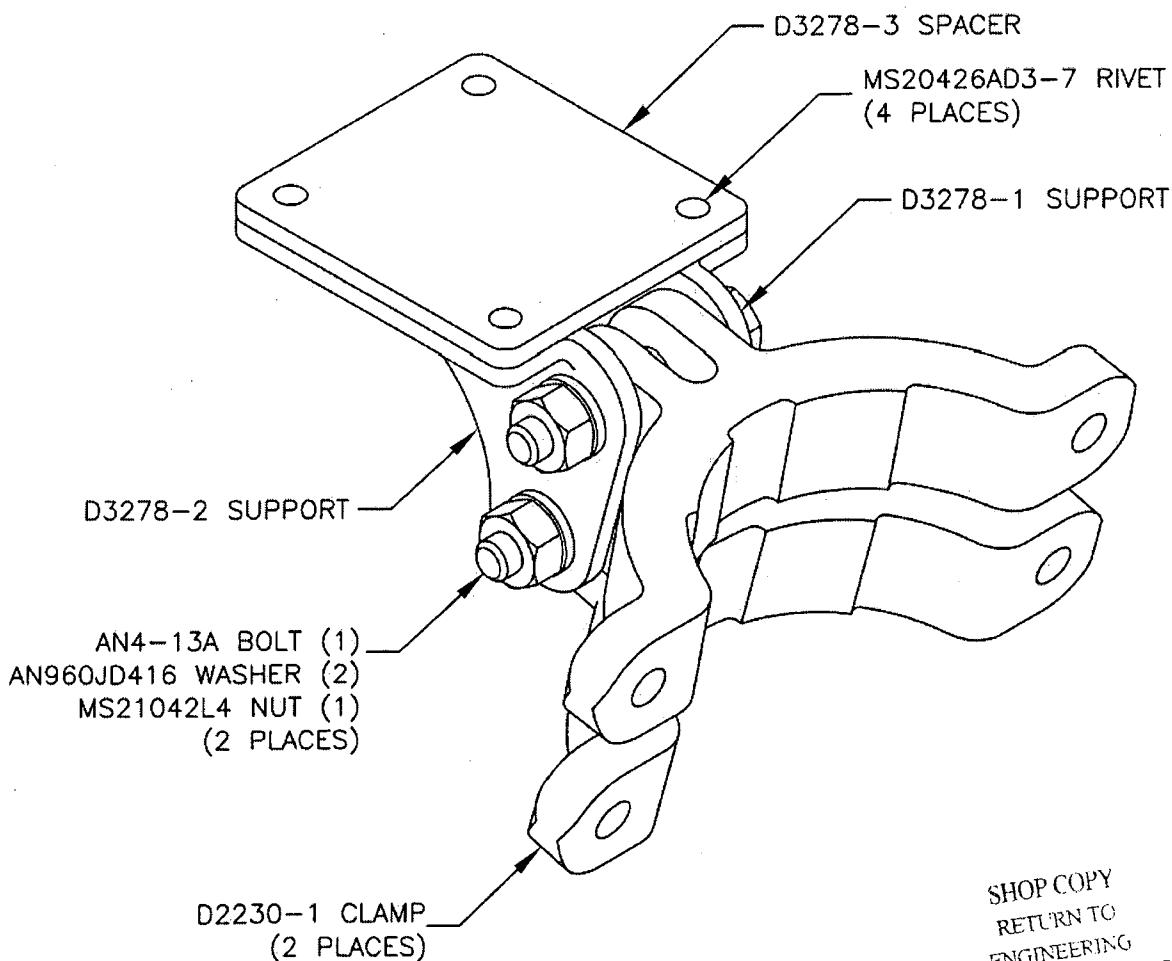
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278
DATE 05.03.31		REV. B SHEET 1 OF 3
		TITLE SUPPORT ASSEMBLY
		SCALE NTS
A	04.03.03	NEW ISSUE
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT

RELEASED
05.04.04

D3278-041 SUPPORT ASSEMBLY



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NO. *30276*

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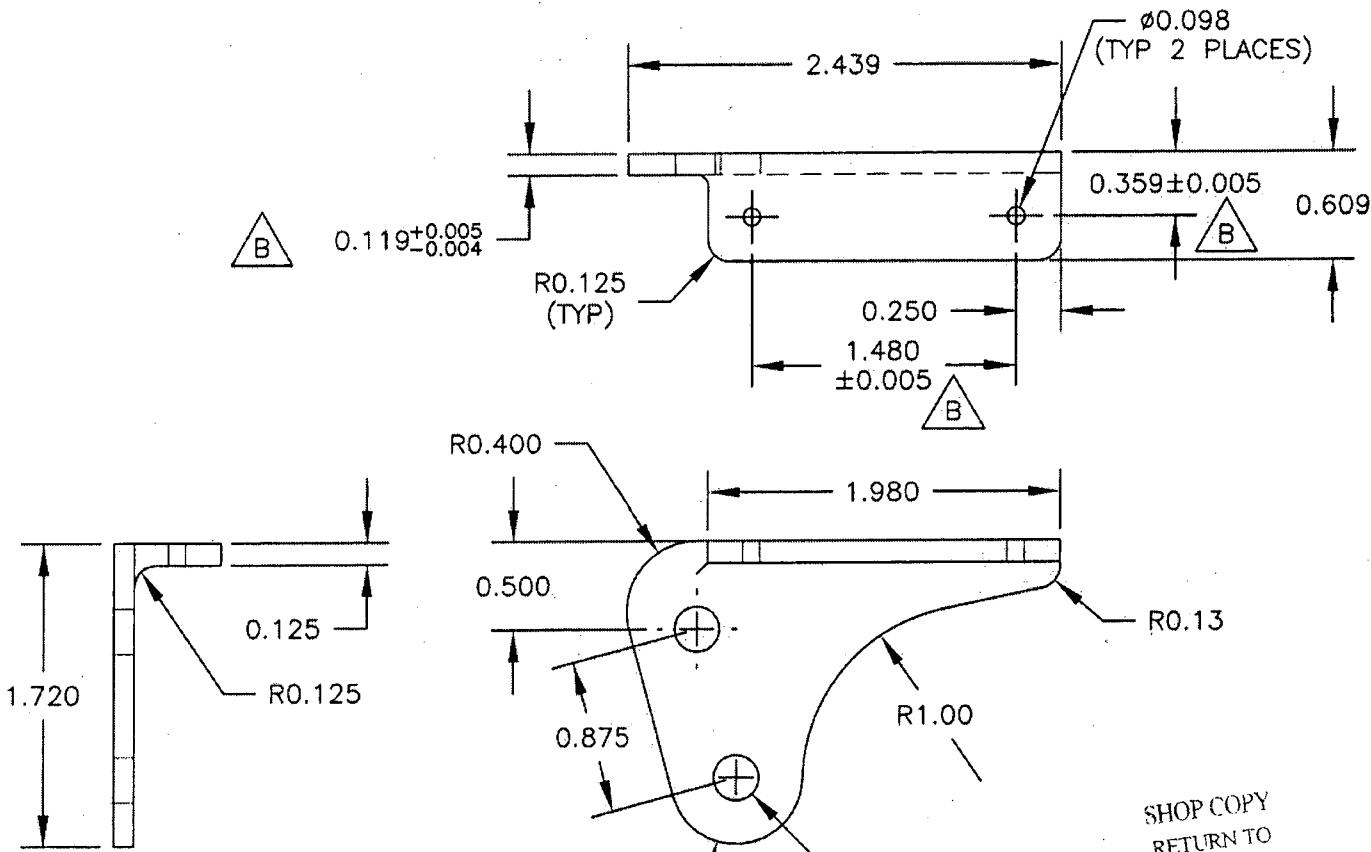
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DART

DESIGN CHECKED DATE	DRAWN BY APPROVED DATE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. TITLE	REV. B SHEET 2 OF 3 SCALE 1:1
CP 05.03.31	CP 05.03.31	D3278 SUPPORT ASSEMBLY	

RELEASED

05.04.04

D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

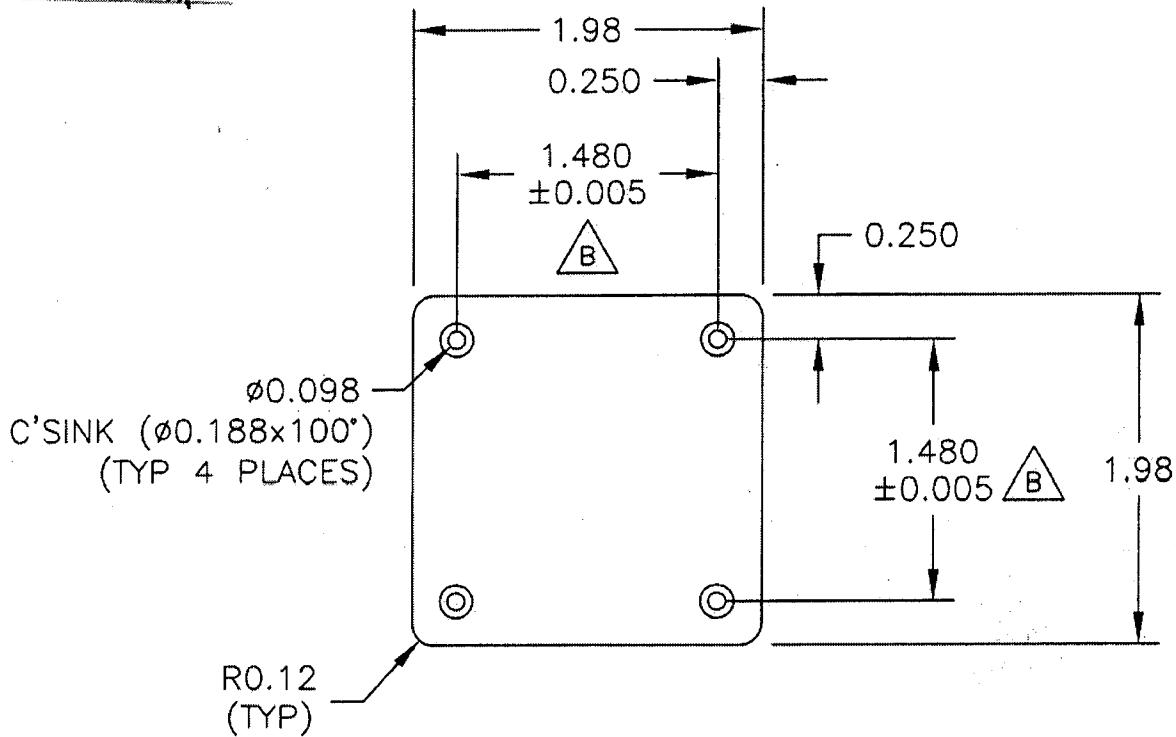
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278 REV. B SHEET 3 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY SCALE 1:1

RELEASED

05.04.04 *[initials]*

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D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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